

Date: Wednesday, 10/06/2009 10:33:29 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	RIB/ GUSSET ASSY
Job Number :	48431		
Estimate Number :	13651		
P.O. Number :		Part Number :	D3826041
This Issue :	10/06/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3826 REV B
First Issue :	09/06/2009	Project Number :	N/A
Previous Run :	47571	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	<u>JUD 09.06.10</u>	Due Date :	16/06/2009
Comment :	Est Rev.A 08-12-01 new issue DD verified by:EC Est Rev.B 09.04.27 rev B dwg EC verified by:DD		

Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22351	Basket Rib
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

✓ Basket Rib

batch: B 48319 → 6x

JM 09/06/16

2.0	D3929041	Gusset Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

✓ Support Gusset (350 Basket)

batch: B 47958 → 5x B 47880 → 1x

JM 09/06/16

3.0	D3929042	Gusset Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

✓ Gusset Assembly

B 47959 → 5x B 47881

JM 09/06/16

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- use DT9434 to assemble D3929 support gusset together

2- locate D3929 on rib and weld as per dwg D3826

A/R ER316 S.S. Rod Batch: M109213

JM 09/06/16 (6)

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

JD 09.06.16 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/06/2009 10:33:29 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB/ GUSSET ASSY

Job Number: 48431

Part Number: D3826041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 09.06.16 (6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Basket cell*

MF 09/06/16 (6x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/17

Job Completion



MF 09-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

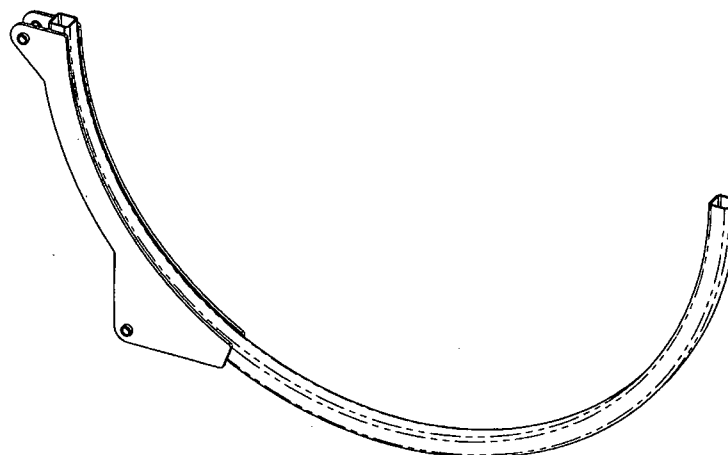
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY



D3826-041 RIB/GUSSET ASSY

RELEASED
09/04/16

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 3.32 lbs

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 NO 148431

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2). UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.		MB	09.04.16
A	NEW ISSUE		MB	08.09.23
REV.	DESCRIPTION		BY	DATE
DESIGN	DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	MFG. APPR.		DRAWING NO. REV. B D3826 SHEET 1 OF 2	
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B D3929-042
GUSSET ASSEMBLY

B D3929-041
GUSSET ASSEMBLY

TYP

0.250

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

RELEASED
3/24/12

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
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